



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3802-21
Job Sheet 194432



Part No: RBE350A93-3802-21

Job Qty: 4 pcs

Part Name: Yoke, Immobilizing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/2/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *Order 15689*

Note: DWG RBE350A93-3802-21 Rev.A IPP Rev. A 18.12.12 New Issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	4 pcs		6/20/19	0.00	0.80	Waterjet - Omax		<i>06/19/06/04</i>
110	QC 2	4 pcs		6/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		<i>06/19/06/04</i>
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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140 QC 8	4 pcs	6/20/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JUN 05 2019
				QC 8 - 52	
				QC 8 - 23	
145 Handfinish -7-1-BeadBlast-B4B	4 pcs	6/20/19	0.00 0.40	Handfinish - 7 - 1 - B4B	8 FEB 19-06-05
				Handfinish - 7 - 2 - B4B	
150 QC 5	4 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUN 05 2019
155 Small Fab - Brake NC - B4B	4 pcs	6/20/19	0.00 0.40	Small Fab - Brake - 1 - B4B	2019
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
160 QC 5	4 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
QC 5 - 3					

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				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170	Outsource - 13 - Zinc Plating	4 pcs	6/20/19	GRO002-VC	2019-07-24
180	Packaging 2-1 - Receive - B4B	4 pcs	6/20/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
190	QC 6	4 pcs	6/20/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
210	Packaging 3-1 - Stock - B4B	4 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
Plex 5/2/19 10:12 AM Dart.lajeunesse.marie					

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MU
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
220 QC 21 - FG	4	6/20/19	0.00 0.00	QC 21 - FG - 21	21
	pcs			QC 21 - FG - 70	9-25
				QC 21 - SA - 53	JUL 30 2019

Part Op 100 - 1-Cut as per DWG. DWG. Rev: A PROG. Rev: A 2-Deburr if necessary
 Descriptions: 145 - Remove scale.
 155 - Form as per DWG.
 160 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 170 - Issue P/O: 44114 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of
 Conformity is required
 180 - Certificate of Conformity is required

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.188	Hot Rolled Steel Plate 0.1889" (44W)	.8400 sf (.21 ea)	100-Waterjet - Omax - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-HRS-P-0.188	1	2	0

Part Specifications	
Specifications could not be found.	

GA
TBD

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DART AEROSPACE LTD		Work Order:	194432
Description: YoKe Immobilizing		Part Number:	
Inspection Dwg: RBE35M493-3800-21 Rev: A		Page 1 of 1	

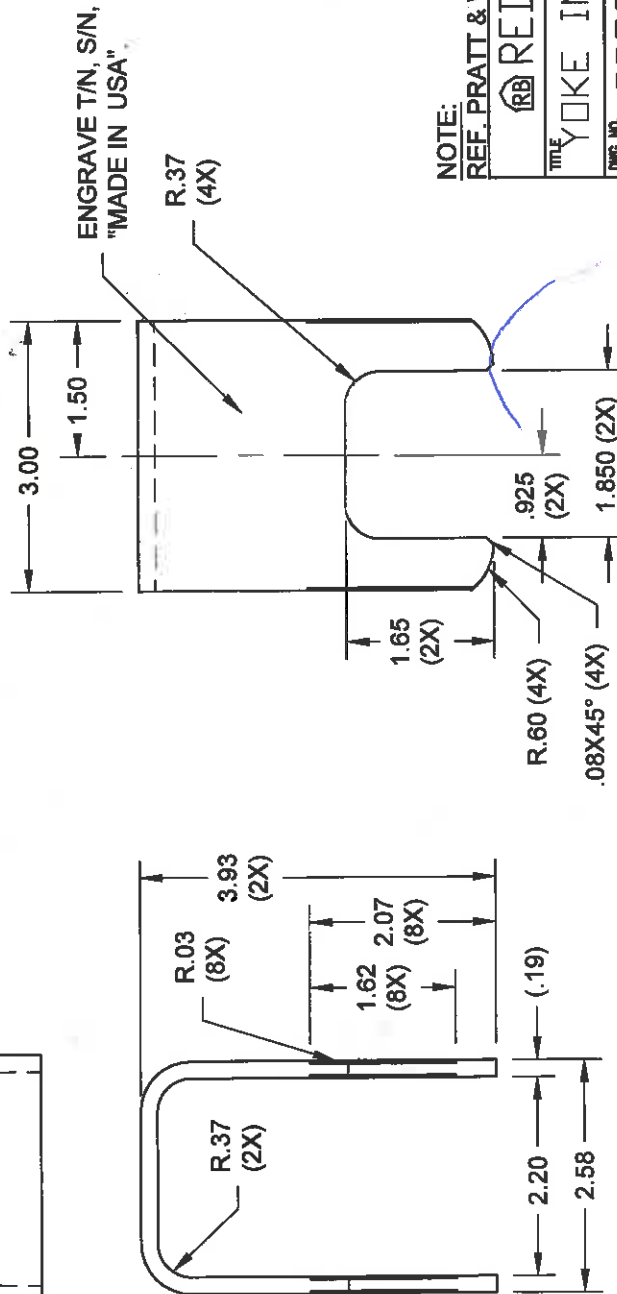
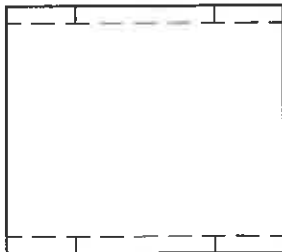
INSPECTION SHEET

Measured by:	JRB	Checked by:	40 9-89	QC Inspector:	
Date:	06/04/19	Date:	JUN 05 2019	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19-4432 1105
190502



NOTE:

REF. PRATT & WHITNEY T/N: 350A93-3802-21.

RED BARN MACHINE

YOKE IMMOBILIZING TOOL

DWG NO. RBE350A93-3802-21 REV A

UNLESS OTHERWISE SPECIFIED		DATE	8-12-09	SHEET	1 of 1
DIMENSIONS ARE IN INCHES		DATE	8-12-09	SHEET	1 of 1
TOLERANCES ON:		DATE	8-12-09	SHEET	1 of 1
DECIMALS		DATE	8-12-09	SHEET	1 of 1
XXX ± .006		DATE	8-12-09	SHEET	1 of 1
XX ± .01		DATE	8-12-09	SHEET	1 of 1
X ± .05		DATE	8-12-09	SHEET	1 of 1
FRACTIONS ± 1/32		DATE	8-12-09	SHEET	1 of 1
ANGLES ± 5°		DATE	8-12-09	SHEET	1 of 1
UNLESS OTHERWISE SPECIFIED		DATE	8-12-09	SHEET	1 of 1
1. BREAK ALL SHARP EDGES		DATE	8-12-09	SHEET	1 of 1
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DATE	8-12-09	SHEET	1 of 1
USED ON MODEL		DATE	8-12-09	SHEET	1 of 1
EUROCOPTER 350A		DATE	8-12-09	SHEET	1 of 1
DRAWN BY: PERRITT		DATE	8-12-09	SHEET	1 of 1
APPROVED: [Signature]		DATE	8-12-09	SHEET	1 of 1
FINISH: YELLOW ZINC PLATE		DATE	8-12-09	SHEET	1 of 1
SPEC:		DATE	8-12-09	SHEET	1 of 1

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐																															
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042) _____																													
Description Work Order Deviation				Disposition																															
Completed By				Lead hand / Supervisor																															
								QC / QA Coordinator																											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
Bending	Misaligned/off center	Folio/Program	Outside Tolerance																																
Crushing	BOM/Route	Grain Direction	Drawing																																
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																
Mislabeled	Fit/Function	Off-set/Set-up																																	
		Other/Details: _____																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044114



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044114

PO Date: 7/24/19

Due Date: 8/1/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-25

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194431	RBE350A93-3800-20	Yoke Immobilizing Tool -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	2 pcs	0 pcs	2 pcs	\$22.50/pcs	\$45.00
				XZ			JUL 30 2019				DP
2	194432	RBE350A93-3802-21	Yoke, Immobilizing -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/1/19	2 pcs	0 pcs	2 pcs	\$22.50/pcs	\$45.00
				XZ			JUL 30 2019				DP
Grand Total:											\$90.00

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044114



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/25/19 1:02 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021042-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021042- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Jul-2019		Jigar Patel		POHB044114				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3800-20 Rev.	RBE350A93-3800-20 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2, SC 2	ZINC CH	2	2	0	0	0
2	RBE350A93-3802-21 Rev.	RBE350A93-3802-21 01-ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2, SC 2	ZINC CH	2	2	0	0	0

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RECEIVED
 JUL 30 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jr. Jay

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.